

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024613**Date Inspected:** 14-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Ji Cai Fang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

**WELDING**

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

**Shielded Metal Arc Welding (SMAW)**

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020F-027/036 located on the OBG Segment 14W. The welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3013AA-087 located on the OBG Segment 13AW. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20131.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3014S-052 located on Vertical Plate to Edge Plate of the OBG Segment 13CW. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-CWR2625.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as AH3002A-003 and 004 located on the OBG Segment 13BW. The welder is identified as 069494. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as AH3002A-003 and 0004 located on the OBG Segment 13BW. The welder is identified as 069494. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3013AA-057 located on the OBG Segment 13AW. The welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR20128.

### Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3015-001-004 located on Deck Panel of the OBG Segment 13CW. The welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-ESAB-Repair and B-WR20059.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3014F-085 and 090 located on Bottom Panel of the OBG Segment 13BW. The welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-ESAB-Repair and B-WR19634.

During random in process observations of OBG Segment 13CW, this QA inspector observed ZPMC personnel performing oxyacetylene gas cutting method to remove temporary attachment on deck panel of the OBG Segment 13CW. This QA performed Visual Testing (VT) of the Deck Panel and found they appeared to be in general compliance with the applicable contract documents. See Photo "A".

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Singh,Vikram	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

---